

Date: Wednesday, 10/3/2007 8:39:16 AM  
 User: Kim Johnston

## Process Sheet

|                       |   |                  |                 |
|-----------------------|---|------------------|-----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services               | Drawing Name     | : STEP WELDMENT |
| Job Number            | : 34987   |                  |                 |
| Estimate Number       | : 11123   |                  |                 |
| P.O. Number           | : <i>NIA</i>  | Part Number      | : D2460         |
| This Issue            | : 10/3/2007   | S.O. No.         | : <i>NIA</i>    |
| Prsht Rev.            | : NC  | Drawing Number   | : D2460 REV D   |
| First Issue           | : <i>NIA</i>  | Project Number   | : N/A           |
| Previous Run          | : 33212   | Drawing Revision | : D             |
|                       |   | Material         | : <i>NIA</i>    |
| Written By            | : <i>[Signature]</i>                                | Due Date         | : 10/25/2007    |
| Checked & Approved By | : <i>[Signature]</i>                                | Qty:             | 4 Um: Each      |
| Comment               | : Est Rev: F Added Finish as per Rev D 05-11-30 JLM |                  |                 |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |                |
|-----|----------|----------------|
| 1.0 | D2244116 | Step Extrusion |
|-----|----------|----------------|



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

|     |        |                |               |
|-----|--------|----------------|---------------|
| Qty | Part # | Description    | Batch         |
| .5  | D2244  | Step Extrusion | <i>328216</i> |

*KE 01-10-17*

4

|     |        |         |
|-----|--------|---------|
| 2.0 | D23381 | End Cap |
|-----|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch No.     |
| 1   | D2338-1     | End cap     | <i>331209</i> |

*KE 01-10-17*

4

|     |        |         |
|-----|--------|---------|
| 3.0 | D23382 | End Cap |
|-----|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch No.     |
| 1   | D2338-2     | End cap     | <i>331210</i> |

*KE 01-10-17*

4

|     |       |              |
|-----|-------|--------------|
| 4.0 | D2459 | 204 Step Lug |
|-----|-------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch No.     |
| 1   | D2459       | Lug         | <i>333233</i> |

*KE 01-10-17*

4

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34987

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 per Dwg. D2460

2-Weld per Dwg. D2460

A/R Alum rod

Batch: M105058

3-Deburr

(use DT8793 to locate D2459)

SE 07.10.17  
SE 07.10.17  
SE 07.10.17

4  
4  
4

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07.10.17 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.10.17 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.10.17

(4)

9.0

POWDER COATING

POWDER COATING



M-10 5068



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-10 07/10/18

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per dwg D2460

Batch: ~~M105058~~ M105694

FL 07/10/18 (4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

U 07/10/18 (4)

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/10/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:39:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34987

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PK

C207110/22 (4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)  
10/10/22

Job Completion



ll 07.10.22

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

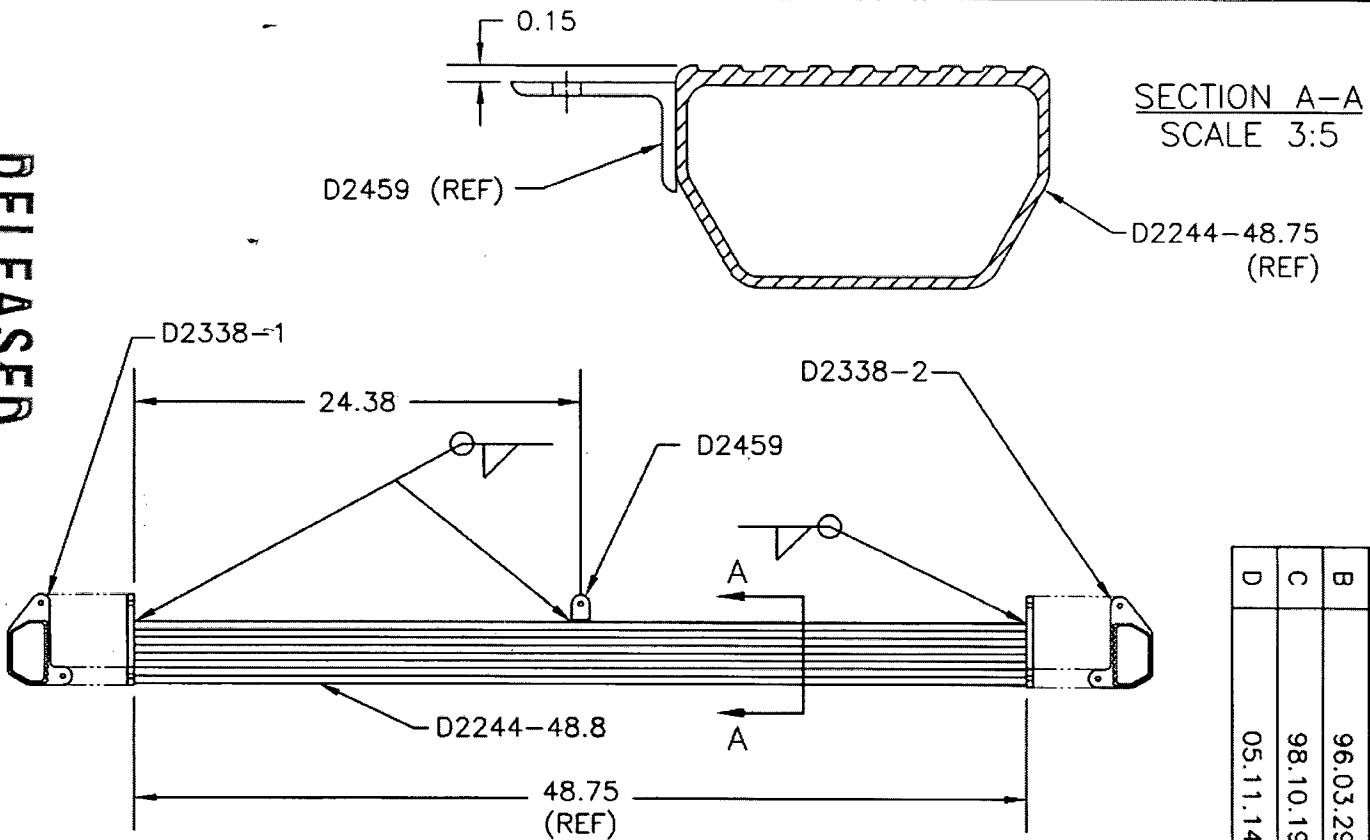
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|         |                    |                              |                        |                             |
|---------|--------------------|------------------------------|------------------------|-----------------------------|
| DESIGN  | BW                 | DRAWN BY                     | PH                     | DART AEROSPACE LTD          |
| CHECKED | <i>[Signature]</i> | APPROVED                     | <i>[Signature]</i>     | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 05.11.14           | DRAWING NO.                  | D2460                  | REV. 0                      |
|         |                    | TITLE                        | STEP WELDMENT ASSEMBLY | SHEET 1 OF 1                |
| A       | 95.01.25           | NEW ISSUE                    |                        | SCALE 1:10                  |
| B       | 96.03.29           | CHANGE END PLATES            |                        |                             |
| C       | 98.10.19           | ADDED SECTION A-A (TSR A915) |                        |                             |
| D       | 05.11.14           | UPDATE FINISHING NOTES       |                        |                             |



**D2460 STEP WELDMENT ASSEMBLY PARTS LIST**

| P/N        | DESCRIPTION            | QTY |
|------------|------------------------|-----|
| D2460      | STEP WELDMENT ASSEMBLY | X   |
| D2244-48.8 | EXTRUSION*             | 1   |
| D2338-1    | ENDPLATE               | 1   |
| D2338-2    | ENDPLATE               | 1   |
| D2459      | ANGLE                  | 1   |

\*cut per drawing

**D2460 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34287

RELEASED  
05.11.28